



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 65229**

January 10, 2011 10:00:29 AM



Page 2

Item ID: D4184-9

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Main Case Solenoid Cover

Start Date: 1/10/11 Start Qty: 2.00



Cust Item ID:

Required Date: 1/28/11 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

B.A 11/01/20

2

Ø

Memo

0.00

130



QC

Quality Control

QC8- Inspect parts - second check

0.00

ml 11-1-24

2

Ø

Memo

0.00

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

H 11/01/21

2 Ø

Memo

0.00

W/O:		WORK ORDER CHANGES					
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 65229

January 10, 2011 10:00:29 AM

Page 3

Item ID: D4184-9

Accept

Setup Start

Revision ID: PRELIM

Stop

Item Name: Main Case Solenoid Cover

Start Date: 1/10/11 Start Qty: 2.00

Cust Item ID:

Required Date: 1/28/11 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150 QC3- Inspect Part Finish 0.00



QC Memo 0.00

Quality Control

180 Identify as per dwg & Stock Location: *Prep* 0.00



Packaging Memo 0.00

Packaging

190 QC21- Final Inspection - Work Order Release 0.00



QC Memo 0.00

Quality Control

*2 Bl 11-a-24*

*2 11 03 13*

POSITIVE RECALL

EFFECTIVE *11-01-10* AUTH *LA*

RELEASED \_\_\_\_\_ DATE \_\_\_\_\_

*RD1344*

*pl 11-06-9*

*2*

*Card*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

Handwritten: *Handwritten*  
Initial all entries

# Picklist Print

Page 1

January 10, 2011 10:00:29 AM

Work Order ID: 65229



Parent Item: D4184-9



Parent Item Name: Main Case Solenoid Cover

Start Date: 1/10/11

Required Date: 1/28/11

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 10-11-07 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.500X01.25 0		Purchased	No			100	f	15.9140	0.116	0.244211			



6061-T6 Bar .500 x 1.25

Location

Loc Qty

Loc Code

MAT02

15.914

103019

8.5

✓7872

7.414

0.244211

B.A 11/01/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**FIRST ARTICLE INSPECTION CHECKLIST**

<input checked="" type="checkbox"/>	First Article	<input checked="" type="checkbox"/>	Prototype
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Measured by: <u>B. A.</u>	Audited by: <u>[Signature]</u>	Prototype Approval: <u></u>
Date: <u>11/01/20</u>	Date: <u>11-1-24</u>	Date: <u></u>

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NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT  
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## Receiving Report

Date: 00-04-26  
 Supplier: Copper Beam Sales

Batch No: M 7872  
 Dart P/O: 200 2446

Packing Slip: Yes ☒ No ☐  
 Invoice: Yes ☐ No ☒  
 Receipt: Cash ☐ Cr. ☐

Release Note Attached: Yes ☒ No ☐ N/A ☐  
 Waybill Attached: Yes ☐ No ☒  
 Shipment Complete: Yes ☐ No ☒

### Discrepancies

Part No.	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments
	<u>Alum sheet</u>	<u>240</u>	<u>0</u>	<u>0</u>	<u>240</u>	<u>B/D</u>

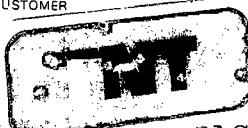

TSR No. \_\_\_\_\_

Production/Admin: \_\_\_\_\_  
 Date: 00/04/26  
 Received/Costing: 2-2446  
 Initial: SP

Initials of receiver (if shipment OK) SP  
 REV A

Accounting: \_\_\_\_\_  
 Date: \_\_\_\_\_  
 AP/MR: \_\_\_\_\_  
 Initial: \_\_\_\_\_

m:\admin\product\recsio

CUSTOMER 		SHIP DATE 04/24/00 SHP		GROSS WEIGHT 95		QUOTE 30-21633-3		7 3		PACKING LIST	
BI AEROSPACE		WORK ORDER ** U33478				ORDER DATE 04/18/00 ORD		TEST RESULTS			
SHIP TO DART AEROSPACE 1270 ABERDEEN ST HAWKESBURY ON CANADA K6A 1K7				01		DELIVERY DATE 04/24/00 DEL		SHIP BRANCH 30 (03)		WORK ORDER U33478	
CUSTOMER P.O. NUMBER 2002446				TERRITORY 01		ENTRY ID 30RDL		 <b>COPPER AND BRASS SALES</b> (CANADA) 100 WILKINSON RD UNITS 13 - 15 BRAMPTON ON CANADA L6T 4Y9			
BUYER KRISTINA YOUNG				INSIDE SALES 30RDL RICHARD D. LACELLE							
BUYER TELEPHONE (613) 632-3336				INSIDE SALES TELEPHONE (416) 675-5941 340							
SHIP VIA				SHIPPING STATUS							
IN TERNAL				COMPLETE X		PARTIAL		CANCEL		DATE:	
TO CUSTOMER COMMON/TST				FOB DEST		CUSTOMER SIGNATURE:					
BILL OF LADING				FREIGHT STATUS PPD		QUANTITY		ORDERED		SHIPPED	
PART DESCRIPTION RECT 6061-T6511 EXTR ALUMINUM BAR 1/2 X 1-1/4 -DART AEROSPACE NO PROCESSING - 144" ML Cust PART No: M6061T6550x1250. Test Results Attn to: QA Department. Sheet must be packaged well to protect from damage in transit. Customer will refuse delivery if damaged. Mill test reports to accompany all shipments.				019969-5		INVENTORY		70.56 LB		71.00	
						BILLING		1.00 LT		1.00	
						WAREHOUSE		✓ 8.00 PC			
						PACKED WITH OTHER GOODS					
						FINISHED GOODS LOCATION					
FULL		SCRAP		FILLED BY SI		PACKED BY		Q/A AUDIT			
CUSTOMER RECEIVING HOURS								MAXIMUM SKID WEIGHT			
LOADING INSTRUCTIONS								MAXIMUM BUNDLE WEIGHT			
BOXES	BARs	CASES	CUSHP	PKGS	SKIDS	BDLS	TUBES	CTNS	FLAT	COILS	
									1		
SPECIAL INSTRUCTIONS shipping co - do not place any packages or goods on top of our material!!!!!!!!!!											
INSPECTION RECORD											

### TEST RESULTS ----- CERTIFICATE OF COMPLIANCE

We hereby certify that mercury or any of its compounds are not used in the processing and distribution of our products. We hereby certify that the material above complies with the following specifications:  
 ASTM-B221-96                      AMS-QQ-200

TAG NUMBER	71.00	LB	ALCOA EP	0846315	797165
	QUANTITY	UNIT	VENDOR	VENDOR PO	HEAT/LOT

MARY L. TAYLOR

- General Manager: TORONTO

PRINTED 04/20/00 09:48 AM

CONTROL NO 00092

**ALCOA**

Alcoa Engineered Products  
 Cressona, PA 17929  
 (570) 386-5000

CERTIFIED INSPECTION REPORT  
 AND TEST RESULTS  
 WROUGHT PRODUCTS

CODE NUMBER

00301902

ORDER NUMBER

OH 797307

COPPER & BRASS SALES INC  
 17401 TEN MILE ROAD

EAST DETROIT

MI 48021

INVOICE NO

INVOICE DATE

GROSS WEIGHT

3074

B/L NO

810819

DATE SHIPPED

/ /

COPPER & BRASS SALES INC C  
 5755 GRANT AVENUE

OPEN TOP TRUCK  
 FOB

CLEVELAND

OH 44105

DEST N

CUSTOMER P.O. NO

GOVT CONTRACT NO

AUTHORIZED SIGNATURE(S)

846315

Products as follows

*Elizabeth J. Chirico*  
 ELIZABETH J. CHIRICO

11/10/99

QUALITY SYSTEMS MANAGER

ASTM B 221-96

QQ-A-200/8F AMS-QQ-A-200/8

ASME SB 221

MEETS T6 TEMPER REQUIREMENTS  
 MARKED

We hereby certify that the material covered by this report has been inspected and tested in accordance with the Seller's standard sampling plan or the requirements of any specifications of the material described in this report and has been found to meet the applicable requirements described herein, and that samples representative of the material met the composition limits and had the mechanical properties shown. Also, note that Mercury is not a normal contaminant in aluminum alloys. Neither Mercury nor any of its compounds are used in the manufacture of our extrusions

ORDER NUMBER

ALLOY AND TEMPER

797307

6061-T6511

Alcoa Engineered Products

ITEM	ITEM DESCRIPTION	PRODUCT CODE	QUANTITY SHIPPED	
			PCS, FT, ETC	WGT. IN LBS. OR AS INDICATED
004	C/P 0199605 RECTANGULAR BAR .500 X 1.250 SEC .500 1.250 .000 LEN 12' WFC ( W .73 F 05 C 1.30 )	L10045	344 PC 4128.0 FT 6 BNDLS	3037

# MECHANICAL PROPERTIES

LOT NUMBER	RACK IDENT	NUMBER OF TESTS	STRENGTH KSI				CONDUCTIVITY		ELONG % IN 2" OR 4D	
			TENSILE		YIELD**					
			MIN	MAX	MIN	MAX	MIN	MAX	MIN	MAX
784144-001	A /A	4	39.3	45.3	35.5	42.2			14.0	21.0
797165-001	A /B	4	42.3	42.9	38.4	39.2			17.0	18.0

CHEMICAL COMPOSITION IN PERCENT MAXIMUM UNLESS SHOWN AS A RANGE

ALLOY	SILICON	IRON	COPPER	MANGANESE	MAGNESIUM	CHROMIUM	ZINC	TITANIUM
6061	0.40-0.8	0.7	0.15-0.40	0.15	0.8-1.2	0.04-0.35	0.25	0.15

OTH/EACH OTH/TOT ALUMINUM  
 0.05 0.15 REMAINDER

\* KIP PER SQUARE INCH. ONE KIP EQUALS ONE THOUSAND POUNDS  
 \*\* WHEN 2 OR MORE TESTS PER RACK ARE MADE, THE HIGHEST AND LOWEST VALUES ARE REPORTED.  
 \*\*\* TENSILE STRENGTH IS DETERMINED BY THE 0.2% OFFSET METHOD.

Alcoa Extrusions, Inc.